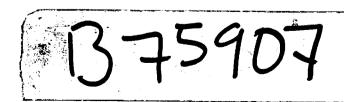
Work Orde		003		*759	903*	·					Page 1
Item ID: Revision ID:	D412-742-01	3		Accept	*N9	იიი4	010 0)* ፡	Setup Star	1/1	S1*
Item Name:	Float Skidtube	Installation							Stop	° *N;	S2*
Start Date:	01/11/2011	Start Qty: 1.00	*1*		Cust	Item ID:					
Required Date:	15/11/2011	Req'd Qty: 1.00	*1*		Custo	omer:					
Reference:			•								
Approvals:	Process Plan	1: M.L.J	Date: \\	<u>○</u> \ Tooling:		Date:		I	Run Star	1/1	R1*
•	QC:		Date:	SPC (Y/N):		Date:			Sto	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Too	ol ID Tool	# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
DSI 9517	В			•							
IIN D412-742	D										
*100 *100*		DOCUMENT CONTRO	L KSP	0.00				A	tage in	125 1	7-1-3
DC		Memo		0.00	1		1) —	·	- <u>-</u>
Document Control		Photocopy b	luefile and create labels		СНФ006	800	ell				
w.		•			CHG 057 49,1.11.88	•	•				
110		Pick Kit		0.00	A 1				<i>[</i>]		,
110 Packaging		Мето		0.00					11/2	4	



Packaging

Dart Ae	rospace L	td						*
W/O:			WC	RK ORDER CHANGE	S			
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	'Approva QC Inspecto
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Res	olution:	Disposition	1:	QA: N/C Clo	sed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	CTED	Description of NC		Corrective Action Section		Verification	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
								,

Work-Order ID 75903 November-01-11 2:24:22 PM				*75903*								Page 2
Item ID: Revision ID: Item Name:	D412-742-01			Accept	*N900	040	100)*	Setup S	tart Stop		S1* S2*
Start Date: Required Date: Reference:	01/11/2011 15/11/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item :	ID:						
Approvals:		n:	_	_		ate:				start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 120 *120* QC Quality Control)	Operation Description QC4- 100% Inspect kits Memo	for completeness	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept	Reject Qty	ľ	Reject Number	Insp. Stamp
*130 *130* Packaging Packaging		Packaging Memo Identify and Location:	pack for shipping as per	0.00 0.00 PPP D412-742-013	<i>)</i>			_/2	1114		·	
140 *140* QC Quality Control		QC21- Final Inspection -	- Work Order Release	0.00					1	2	11 11	24)

MF 12-01-11

Dart	Aeros	pace	Ltd
------	--------------	------	-----

W/O:		WORK ORDER (WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	'Approval QC Inspector						
					, ,								
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	,						

Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC	Corrective Action Section B			Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector					
		7,100											
						·							
							•						

Picklist Print

Novembër-01-11 2:24:29 PM

Work Order ID: 75903

75903

Parent Item:

D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A05.10.13New Issue KJ/JLM

IPP Rev:B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN

1072 DD verified by:JLM

IPP Rev:D 08-09-08 ecn 08-510 DD verified by:EC

Manufactured

No

IPP Rev:E 09-01-23 as per DSI9441 DD verified by:EC IPP RevF: add AN4C7A DD 10.01.13 verified by:EC IPP Rev:G 11.11.01 as per

1	DSI9517 REV.B D	D verified by:E	С										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C53A		Purchased	No			110	Each	21.0000	4	4_			
AN4C53	Δ								**	A CONTRACTOR	88 1	M11969	8
				Location	<u>1</u>	Loc	Qty	Loc Code					
				ST361			21		_		_		
					115723		10		_		_		
					119447		11		_		_		
AN4C7A		Purchased	No			110	Each	315.0000	4	4)			
*AN4C7A	*								**	<i>V_</i>	·		

. 1	
//	D3403-5
MW]	*D3403-5*
7)	Bushing

Location	Loc	e Oty	Loc Code	
ST356		315		
109147		315		
	110	Each	108.0000	8
			*:	*

Location	<u>1</u>	Loc Qty	Loc Code	
FG052		100		
	74761	100		
ST361		8		
	66530	8		







Dart A	erosp	oace	Ltd
--------	-------	------	-----

W/O:		WORK ORDER O	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
<u>,</u>									
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	<u>.</u>		

	STEP Description of No Section A	esolution:	Dispositi	ion:	QA: N/C Clos	sed:	Date:	
NCR:		. 17	WORK ORI	DER NON-CONFORMA	NCE (NCR)			
··· · · · · · · · · · · · · · · · · ·		Description of NC		Corrective Action Section	n B	Verification	Ammassal	Ammercal
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
		,						
	1	1			I		I	l

November-01-11 2:24:29 PM

	November-01-11 2.24.29 1 W								
	Work Order ID: 75903		*7	5903*					
	Parent Item: D412-742-013			412-742-0	ገ13*				
	Parent Item Name: Float Skidtube Ins	stallation	' '	· - · · · · · · · · · · · · · · · · · · ·	, , , ,		S	tart Date: 01/11/2011	Required Date: 15/11/2011
L							5	Start Qty: 1.00	Required Qty: 1.00
AL	D412-742-043	Manufactured	No		110	Each	0.0000	1 1	11//
MAN .	*D412-742-043*							** _ \$75	907 12h/11
	Replacement Float Skidtube D2571	Manufactured	No		110	Each	3.0000	1 1	\cap
MWI +1	*D2571*							** B774	160
1	Saddle, Fwd Out 205			Location	<u>Lo</u>	c Oty	Loc Code		1
				ST433		3			
				72969		3			
MM	D2572	Manufactured	No		110	Each	2.0000	1 1	. 0
MW XI	*D2572* Saddle, Fwd In 205							** B 272	469
,	, - ··· - ·· - ··			Location	<u>Lo</u>	c Oty	Loc Code		
				ST433		2			
,				71107		2			
S	D2573	Manufactured	No		110	Each	0.0000	1 1	
7	*D2573* , Saddle, Aft Out 205							** \$77287	
./	D2574	Manufactured	No		110	Each	0.0000	1 1	
MM T	*D2574*							** B778	Cape
1	/Saddle, Aft In 205						•• •••		
MM	D2876	Manufactured	No		110	Each	23.0000	2 2	$\Lambda \Pi \Lambda$
4	*1)2876* Saddle Spacer							** (376949	Milas
	Saudio Space.			Location	Lo	c Oty	Loc Code	V	
				ST025		23			
				72136		23			

D	art	Aeı	ros	pace	Ltd

Dan Ae	ospace				•				
W/O:			WORK ORDER C	HANGES	 				
DATE	STEP	PRO		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	*Approval QC Inspector	
								:	
Part No):	PAR #:	Fault Category:	NC	R: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition:	QA	: N/C CI	osed:	J	Date: _	
NCR:		V	CONFORMANCE (NCR)						
DATE	STEP	Description of NC Corrective Action Section B				———— Verification Appro			i Approval

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
		•									
	1										
-											
·											

Picklist Print

Work Order ID: 75903

November-01-11 2:24:29 PM

75903

Parent Item:

D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Required Qty: 1.00

Page 3

Start Qty: 1.00

Manufactured

110

Each 87.0000

**

Saddle Spacer

Manufactured No

No

Location Loc Oty ST025 87 21 72135 73309 66 110 Each

Loc Qty

44.0000 **

Loc Code

Manufactured

No

44 15 29 110 Each

126.0000 **

Loc Code

Loc Code

Manufactured No

Location Loc Qty ST021 126 71163 26 73495 100 110

Each

84.0000 **

Location ST065 73310

Location

70696

75672

ST052

Loc Oty 84 84 Loc Code

Dart Aerosp	pace Ltd
-------------	----------

W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Y	es No DQ	A:	Date: _	
	Resolution	:	Disposition:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDER NON-COM	IFORMANCE (N	CR)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
	1		1									

Picklist Print

November-01-11 2:24:29 PM

Page 4

Work Order ID: 75903

75903

Parent Item:

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

Location

FG

ST356

Location

ST361

D412-742-013

103344

116704

118451

118983

119328

118422

110

Loc Oty

326

15

11

100

Each 330.0000

Loc Code

16

**

Purchased

No

No

110

200 Each

61.0000 **

Purchased

No

117163 117688 118451

46 110 Each

Loc Qty

61

16.0000 **

Location ST341

Loc Qty 16 16 Loc Code

Loc Code

Dart Aeros	pace Ltd
------------	----------

W/O:			WORK ORDER CHANGES									
DATE	STEP		PROCEDURE CHANGE	В	y Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	<u> </u>	PAR #:	Fault Category:	NCR: Y	es No DC)A:	Date:					
		solution:										

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval	Annuoval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector				
							:					
	1											

NOTE: Date & initial all entries

Picklist Print Novembér-01-11 2:24:29 PM									Page
Work Order ID: 75903		*7	5903*						
Parent Item: D412-742-013 Parent Item Name: Float Skidtube In	stallation		412-742-0)13*			rt Date: art Qty:	1.00	Required Date: 15/11/2011 Required Qty: 1.00
D3672-3 *D3672-3* Phenolic Washer	Manufactured	No		110	Each	691.0000	32 **	\sim	
THEHOTE WASHES			Location ST074 64176 72230 73487	<u>Lo</u>	691 180 11 500	Loc Code		32	- - -
*AN960C416L *AN960C416L * WASHER	Purchased	No		110	Each	0.0000	32 **	32 MII 72	71
D3672-9 *D3672-9* Phenolic Washer	Manufactured	No		110	Each	232.0000	* *	8	,
			Location ST074	<u>Lo</u>	232 232	Loc Code		8	- -
NAS1149C0632R *NAS1149C0632 WASHER	Purchased	No		110	Each	88.0000	* *		
			<u>Location</u> ST297 118006	Lo	<u>c Oty</u> 88 88	Loc Code		8	- - 0
D3672-11 *D3672-11*	Manufactured	No		110	Each	99.0000	* *	1/1/3	

Phenolic Washer

Location Loc Oty Loc Code

ST074 99 -58046 99

W/O:		WORK ORDER C	HANGES		-		
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	 A:	Date:	

	Resolution:	olution:	Dispositio	on:	QA: N/C Clos	sed:	Date:		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)	·			
	T	Description of NC	on B Verification		Approval	Approval			
DATE	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
							 		
								, ,	

November-01-11 2:24:29 PM

Work Order ID: 75903 *75903* *D412-742-013* Parent Item: D412-742-013 Parent Item Name: Float Skidtube Installation **Required Date: 15/11/2011** Start Date: 01/11/2011 Required Qty: 1.00 Start Qty: 1.00 MS21043-4 110 1,105.000 Purchased No Each ** Loc Code Location Loc Qty FG 40 104603 40 ST301 1065 65 117793 500 118686 119309 500 D3403-3 110 Each 13.0000 Manufactured No ** Location Loc Qty Loc Code ST 69509 3 ST052 10 10 71852 110 12,0000 Manufactured No Each ** Location Loc Qty Loc Code ST474 12 2 62227 73338 10

	. oopaoc								
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						:			
		PAR #:	Fault Cate	gory:	NCR: Ye	s No DQ	A :	Date: _	
Resolution:		esolution:	Disposition	n:	_ QA: N/C	Closed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NO	R)			
		Description of NC	Corrective Action		on B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	l& ∣ _{Sec}	tion C	Chief Eng	QC Inspector
	i		1			1		1	1

Picklist Print November-01-11 2:24:29 PM			-						Page
Work Order ID: 75903		*7	5903*				-		
Parent Item: D412-742-013			412-742-0	142*					
Parent Item Name: Float Skidtube	Installation	1)	41/-14/-	11.7		S	tart Date:	01/11/2011	Required Date: 15/11/2011
							Start Qty:		Required Qty: 1/00
D3405-043	Manufactured	No		110	Each	6.0000	1	1	/ /
D3405-043	Transitation of the second						**	B7	6999
			Location	<u>L</u> c	e Qty	Loc Code			/
			ST423		2				
			65703		2				
			ST478		4				_
			73339		4)
AN4C47A	Purchased	No		110	Each	57.0000	4	4	
AN4C47A							**	9/	
			Location	<u>La</u>	e Qty	Loc Code			
			ST361		57				
			117163		7			4	
D3407-041	N	No	118451	110	50 Each	25.0000	1	1	
	Manufactured	No		110	Each	23.0000	**	100	2
D3407-041							**	B76	2239
			Location	Lo	e Oty	Loc Code			
			ST463		25			V-10	
			75029		25				
D3417-3	Manufactured	No		110	Each	60.0000	2	2	, []
D3417-3 Washer							**	12/14	25/
			Location	<u>L</u> g	oc Oty	Loc Code			
			FG		9				
			33519		9				

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
	:											

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	l:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
	I	Description of NC	Verification	Approval	Approval							
DATE STEP	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto				
				, , , , , , , , , , , , , , , , , , , ,		·						
		·										

November-01-11 2:24:29 PM

Work Order ID: 75903 *75903* Parent Item: D412-742-013 *D412-742-013* Float Skidtube Installation **Required Date: 15/11/2011** Parent Item Name: Start Date: 01/11/2011 Required Qty: 1.00 Start Qty: 1.00 110 96.0000 Manufactured Each Loc Qty Location Loc Code FG 7 25701 7 ST054 89 66848 71165 73493 110 Each 132.0000 Purchased No ** Location Loc Code Loc Qty ST354 132 116874 11 117010 2 118518 44 1:18709 50 119324 25 110 73.0000 Each Purchased No Location Loc Oty Loc Code ST354 73 23 112454 114442 50

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
					ļ <u>-</u>							

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval	Approval					
DATE	STEP	Section A	initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
	-											
				•								

Picklist Print November-01-11 2:24:29 PM									Page
Work Order ID: 75903		*75	903*						
Parent Item: D412-742-013			112-742-0	12*					
Parent Item Name: Float Skidtube	e Installation	1 /-	+ 1 / - 1 4 / - ()	11.1		St	art Date:	01/11/2011	Required Date: 15/11/2011
						S	tart Qty:	1.00	Required Qty: 1.00
AN3C41A	Purchased	No		110	Each	98.0000	1	\mathbf{A}	
ΛΝ3 <i>C</i> /1Δ							**	<i>t/</i>	
AN3C41A								y	
			Location	Lo	c Oty	Loc Code		/	
			FG		4				_
			103324		4				_
			ST354 119035		94 44				
٨			119324		50			/	_
MAN3C42A	Purchased	No		110	Each	38.0000	1	Α	
AN3C42A							**	S	
BOLT			<u>Location</u>	<u>Lo</u>	e Qty	Loc Code		,	
			ST354		38				_
			106176 117763		1 17			1	_
1			118131		20			(_
AN3C43A	Purchased	No		110	Each	38.0000	4	A	
AN3C43A							**	#	
BOLT			Location	Lo	c Oty	Loc Code	/		
			ST354		38				_
			114455 118387		13 25			✓	maration.
AN3C46A	Purchased	No	110307	110	Each	47.0000	5	5 1	
AN3C46A	1 41 41 41						**	12/1/2	<i>\$</i>
i ROFI			Location	<u>Lo</u>	c Oty	Loc Code			
			ST355		47			~	_
			118758		47			<u> </u>	_

Shop Packet Print

November-01-11 2:24:29 PM

Page 9

W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·					
Part No	:	PAR #:	Fault Category:	NCR: Y	es No DQ	A:	Date:	
Resolution:		n:	Disposition:	QA: N/C Closed:		Date: _		
NCR:			WORK ORDER NON-COM	FORMANCE (N	CR)			

WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B		Varification	Approval	A	
STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	Approval QC Inspector	
	*							
	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Chi	STEP Description of NC Section A Chief Eng Chi	STEP Description of NC Section A Chief Eng Corrective Action Section B Sign & Date Verification Section C	STEP Description of NC Section A Chief Eng Chief Eng Section B Sign & Date Chief Eng C	

November-01-11 2:24:29 PM

Work Order ID: 75903

D412-742-013

Parent Item Name: Float Skidtube Installation

75903

D412-742-013

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

Parent Item:

NAS1149C0332 Purchased

No

110

Each

26

26

*AN960C10I *

MS21043-3

Purchased

No

110

Each

727.0000

0.0000

13

**

**

Location	<u>.</u>	Loc Qty	Loc Code	
FG		72		
	103691	72		
ST301		655		
	118077	1		
	118614	477		***
	118686	177		

W/O:			WORK ORDER CHANGES							
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No		PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _			
	Res	olution:	Disposition:	QA: N/C	Closed:		Date: _			

WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC		Corrective Action Section B		Varification	Ammuoval	
DATE STEP Description of NC Section A		Initial Action Description Sign & Chief Eng Chief Eng Date		Section C	Chief Eng	Approval QC Inspector	
						·	
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Description

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3

REF. CANADIAN STC: SH05-37 REF. FAA STC: SR01583SE REF. EASA STC: EASA.IM.R.S.01126

PURPOSE:

The purpose of this service instruction is to introduce an alternate wearplate installation for the D412-742-011/-013 Skidtube Installations. The new DSI-9517-011 Wearplate Kit consists of new wearplates destined to replace existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets. The components in the DSI-9517-011 Wearplate Kit are as defined in the parts list on sheet 4 of this service instruction.

INSTALLATION PROCEDURE:

rshoes and D3566-1/-3 Gaskets v	

- 1. Remove existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets per Item 32.6.1 of ICA-D412-742. It inight be necessary to loosen the aft end of D3564-5 Wearshoe and D3566-5 Gasket.
- 2. Remove qty.(4) AN4C52A Bolts, D3403-1 Bushings, and qty.(8) D3672-11 Washers as indicated in Figures 1 and 2 of this service instruction.
- 3. Inspect the skidtube and saddles per Chapter 5 of ICA-D412-742.
- Seal existing inserts located on both sides of the skidtube in area shown in Figures 1 and 2 of this service instruction using Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class 2B sealant.
- 5. Locate the DSI-9517-011 Wearplate Kit as shown in Figure 1 and 2 of this service instruction.
- Transfer drill qty.(2) Ø0.438 hole from the skidtube/saddle to the D4095-041/-043 Wearplates Assemblies. Deburr. Touch up finish per Item 5.2.14 of ICA-D412-742 as required.
- 7. Install the DSI-9517-011 Wearplate Kit using the same AN3C hardware as shown in ICA-D412-742.
- Torque to 15-25 in-lbs (1.7-2.8 N-m).

 | Install D3403-5 Bushings and AN4C53A Bolts in lieu of D3403-1 Bushings and AN4C52A Bolts removed at step 2 above. Ensure that the nuts on the AN4C Bolts are on the inboard side of the skidtube. Torque to 50-70 in-lbs (5.7-7.9 N-m).
- 9. Amend weight and balance per the Weight and Balance Table below.

WEIGHT AND BALANCE:

Use the following weight and balance information for DART D412-742-011/-013 skidtube and saddle installations equipped with DSI-9517-011 Wearplate Kit.

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL		
		ARM	MOMENT	ARM	MOMENT	
D412-742-011 Float Skidtube Installation with DSI-9517-011 Kit Installed	70:0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kg	130 in 3.3 m	9100 in-lb 105 m-kg	
D412-742-013 Float Skidtube Installation with DSI-9517-011 Kit Installed	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kg	130 in 3.3 m	9100 in-lb 105 m-kg	

HOP COPY

PETURN TO

PAGINEERING

OFFROLLED COPY

OFFC TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

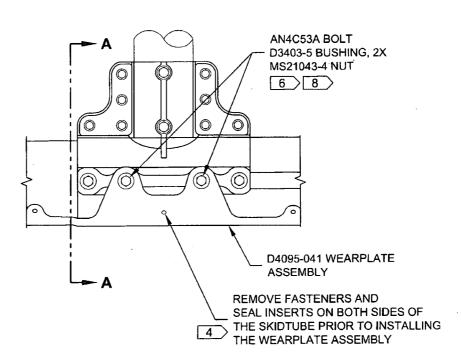
75903 M.C.J

	4. 1	1	
1/	11/	٥	1

В	ITEM 2	1B AND 22	B REMOVED FROM PARTS LIST	XDF	11.10.11		
Α	NEW IS	SSUE		MB	10.04.21		
REV.		1	DESCRIPTION	BY	DATE		
DESIGN		4	DART AEROSPAC	DART AEROSPACE USA, INC			
DRAWN		XDF	KENT, WA				
CHECK	ΞD	_\$	DRAWING NO. R				
MFG. AF	PR.	N/A	DSI 9517	:	SHEET 1 OF 6		
APPRO	VED	10	TITLE		SCALE		
DE APPR. ALTERNATE WEARPI			ALTERNATE WEARPLATE	KIT	NTS		
DATE 11.10.11			THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLI NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUN	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WITHTEN PERMISSION FROM DART AEROSPACE USA.			

ospace .	Liu							
		W	ORK ORDER CHANG	ES				
STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date: _	
							Date:	
	1	WORK ORE	ER NON-CONFORMA	NCE (NC	R)			
STEP	Description of NC Section A	Initial Action Description		Sign	& Secti		Approval Chief Eng	Approval QC Inspector
						-		
							:	
	STEP	PAR #: Resolution:	STEP PROCEDURE CH. PAR #: Fault Cate Resolution: Disposition WORK ORE	WORK ORDER CHANGE PROCEDURE CHANGE PROCEDURE CHANGE Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMA STEP Description of NC Section A Initial Action Description	WORK ORDER CHANGES STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C C WORK ORDER NON-CONFORMANCE (NC) STEP Description of NC Section A Initial Action Description Sign	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQ. Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty :PAR #:Fault Category:NCR: Yes No DQA: Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr E PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Section C Chief Eng (Chief E





WAS:

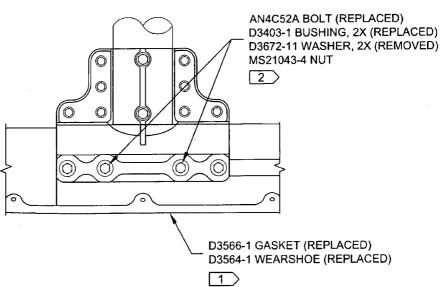


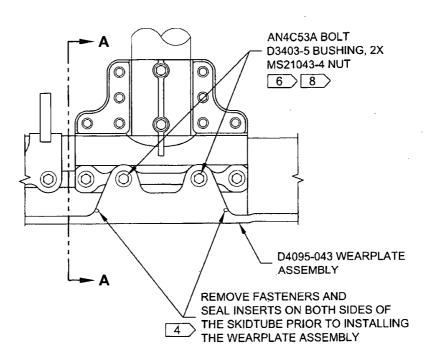
FIGURE 1: CHANGE AT FORWARD SADDLE LOCATION WITH DSI-9517-011 KIT INSTALLED

	1						
DESIGN A		DART AEROSPACE USA, INC					
DRAWN	XPF	KENT, WA					
CHECKED	4	DRAWING NO.	REV. B				
MFG. APPR.	N/A	DSI 9517	SHEET 2 OF 6				
APPROVED	NO	TITLE	SCALE				
DE APPR.	#	ALTERNATE WEARPLATE KIT	NTS				
DATE 11.1	0.11	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OF COMUNICACIENT OF ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.					

2002

	Tospace	<u> </u>							
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Ĺ									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	Date: _	
	Re	solution:	Disposition	1:	_ QA: N/C CI	osed:		Date: _	
NCR:		,	WORK ORDE	ER NON-CONFORMA	NCE (NCF	1)			
		Description of NC		Corrective Action Section B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C	Chief Eng	QC Inspector
İ									

<u>IS:</u>



WAS:

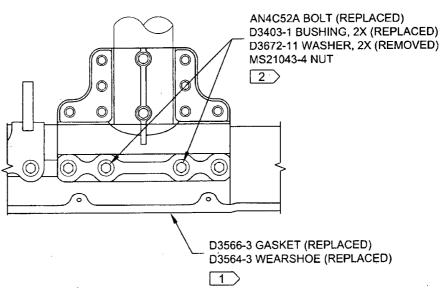
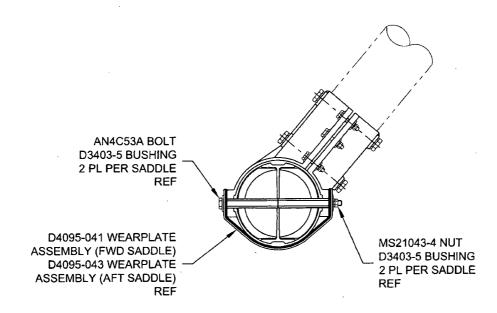


FIGURE 2: CHANGE AT AFT SADDLE LOCATION WITH DSI-9517-011 KIT INSTALLED

	1	· .		
DESIGN	_4	DART AEROSPACE L	JSA, INC	
DRAWN	XDF	KENT, WA		
CHECKED	43	DRAWING NO.	REV. B	
MFG. APPR.	N/A	DSI 9517	SHEET 3 OF 6	
APPROVED	160	TITLE	SCALE	
DE APPR.	4	ALTERNATE WEARPLATE KIT	NTS	
DATE 11.1	0.11	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND COMPIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR MY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION PROM DART AEROSPACE USA INC.		

2020

D uit 710	oopaoc	LIM									
W/O:		17 (1 (1 (1 (1 (1 (1 (1 (1 (1 (1 (1 (1 (1	WORK ORDER CHANGES								
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:									
	Resolution:		Disposition	QA: N/C CK	sed:	Date:					
NCR:		,	WORK ORD	ER NON-CONFORMAI	NCE (NCR)					
DATE	STEP	Description of NC	Corrective Action Sec			Verification		Approval	Approval		
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	on Sign & Date		on C	Chief Eng	QC Inspector		
							:				
					-						
	1 1		1 1		l l	1					



SECTION A-A

DSI-9517-011 PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
Х	DSI-9517-011	WEARPLATE KIT
8	D3403-5	BUSHING
1	D4095-041	WEARPLATE ASSEMBLY
1	D4095-043	WEARPLATE ASSEMBLY
4	AN4C53A	BOLT

DESIGN	4	DART AEROSPACE USA, INC					
DRAWN XDF,		KENT, WA					
CHECKED	4	DRAWING NO.	REV. B				
MFG. APPR.	N/A	DSI 9517	SHEET 4 OF 6				
APPROVED	140	TITLE	SCALE				
DE APPR.	-11	ALTERNATE WEARPLATE KIT' N					
DATE 11.1	0.11	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.					

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:							
	Re	esolution:	Dispositio	1:	_ QA: N/C C	QA: N/C Closed: Date:						
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCF	R)						
DATE	STEP	Description of NC	Initial	on B	Sign & Section C		Approval	Approval				
	JILF	Section A	Chief Eng	Action Description Chief Eng	Date	Sect	ion C	Chief Eng	QC Inspector			
									71-			

THE PARTS LISTS IN SECTION 32.15 OF ICA-D412-742 (PAGES 53 AND 55) AND SECTION 5.1 OF IIN-D412-742 (PAGES 16 AND 17) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

32.15 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742) 5.1 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)

Item	QTY -011	QTY -041	QTY -015	PART NUMBER	DESCRIPTION
	Х			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	Х		D412-742-041	FLOAT SKIDTUBE
	1.		X	D412-742-015	ELECTRIC STEP KIT
IS:			, and the second		1
3		10		AN3C6A	BOLT (REMOVED QTY.2)
4		4		AN3C7A	BOLT (REMOVED QTY.4)
5		38		AN960C10L	WASHER (REMOVED QTY.6)
					1
21A		11		D4095-041	WEARPLATE ASSEMBLY
22A		1		D4095-043	WEARPLATE ASSEMBLY
				·	<u>,</u>
46	8			D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
46A	8			D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
					<u></u>
49	.4			AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
49A	4			AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
			,		·
53	8			D3672-11	WASHER (REMOVED QTY.8)
		•			
WAS:					
3		12		AN3C6A	BOLT
4		8		AN3C7A	BOLT
5		44		AN960C10L	WASHER
لـنــا					1
21A		1		D3564-1	WEARPLATE
21B		1		D3564-3	WEARPLATE
22A		1		D3566-1	GASKET
22B		1		D3566-3	GASKET
				<u> </u>	7
46	16			D3403-1	BUSHING
·			L	I	~
49	8			AN4C52A	BOLT
		·		<u> </u>	1
53	16			D3672-11	WASHER
				L	~V

DESIGN	4	DART AEROSPACE USA, INC					
DRAWN	XDF,	KENT, WA					
CHECKED	А	DRAWING NO.	REV. B				
MFG. APPR.	N/A	DSI 9517	SHEET 5 OF 6				
APPROVED	10	TITLE	SCALE				
DE APPR.	#	ALTERNATE WEARPLATE KIT	NTS				
DATE 11.1	0.11	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR MY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.					

2002

Duitho	oopaoc	EW							
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cateo	jory:	_ NCR: Yes	No DQ	A:	Date: _	
Resolution:		solution:	Disposition	_ QA: N/C CI	QA: N/C Closed: Date: _				
NCR:		1	WORK ORDE	R NON-CONFORMA	ANCE (NCF	R)			
	I	Description of NC	escription of NC Cor		ection B		cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ection C Chief Eng		QC Inspector
		_							

THE PARTS LISTS IN SECTION 32.16 OF ICA-D412-742 (PAGES 57 AND 59) AND SECTION 5.2 OF IIN-D412-742 (PAGES 18 AND 19) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

32.16 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742) 5.2 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)

QTY -013	QTY -043	PART NUMBER	DESCRIPTION
Х		D412-742-013	FLOAT SKIDTUBE INSTALLATION
1	Х	D412-742-043	FLOAT SKIDTUBE
			4
**~	10	AN3C6A	BOLT (REMOVED QTY.2)
	4	AN3C7A	BOLT (REMOVED QTY.4)
	38	AN960C10L	WASHER (REMOVED QTY.6)
			1
1		D4095-041	WEARPLATE ASSEMBLY
1		D4095-043	WEARPLATE ASSEMBLY
8		D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
8		D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
			1
4		AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
4		AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
			1
8		D3672-11	WASHER (REMOVED QTY.8)
	-013 X 1 1 1 1 8 8	-013 -043 X 1 X 10 4 38 8 8 4 4 4	-013 -043 PART NUMBER X D412-742-013 1 X D412-742-043 10 AN3C6A 4 AN3C7A 38 AN960C10L 1 D4095-041 1 D4095-043 8 D3403-1 8 D3403-5 4 AN4C52A 4 AN4C53A

VAS:				4
3	<u> </u>	12	AN3C6A	BOLT
4		8	AN3C7A	BOLT
5		44	AN960C10L	WASHER
	•			1
21A		1	D3564-1	WEARPLATE
21B		1	D3564-3	WEARPLATE
22A		1	D3566-1	GASKET
22B		1	D3566-3	GASKET
		·		
46	16		D3403-1	BUSHING
		*		
49	8		AN4C52A	BOLT
				
53	16	T	D3672-11	WASHER

DESIGN DRAWN	XDF	DART AEROSPACE USA, INC					
CHECKED	4	DRAWING NO.	REV. B				
MFG. APPR.	N/A	DSI 9517	SHEET 6 OF 6				
APPROVED	10	TITLE	SCALE				
DE APPR.	-##	ALTERNATE WEARPLATE KIT					
DATE 11.1	0.11	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.					

Dail Ae	Ospace	s Lla							
W/O:			WC	RK ORDER CHANGE	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	<u> </u>	PAR #:	Fault Cated	dorv:	NCR: Yes	No DQ .	 A:	Date:	
• • • • • • • • • • • • • • • • • • • •			Disposition: QA						
NCR:	<u> </u>	,	WORK ORDE	ER NON-CONFORMA	NCE (NCR)			
		Description of NC	Corrective Action Sect		n B	Varifi	ation	Ammuoval	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Verification Section C	Approval Chief Eng	Approval QC Inspector
									·
·									